

Work Order ID 149054

149054

PRELIMINARY ISSUE

Page 1

Tuesday, July 19, 2016 10:18:01 AM

Item ID: D206-642-522PHI

Accept

N1900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Stop

NS2

Start Date: 7/19/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00

1

Customer:

Reference:

DAS

Approvals:

Process Plan:

21

Date: JUL 19 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-512								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

B147155

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER :																																																																									

Work Order ID 149054

149054

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Tuesday, July 19, 2016 10:18:01 AM

Item ID: D206-642-522PHI
 Revision ID: PRELIM
 Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 7/19/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D206-642-512
 Location: _____

Sold

0.00

0.00

DAS

27

9-89

DAS

26

9-89

AUG 25 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.02

DAS

21

9-89

AUG 25 2016

DAS

21

9-89

AUG 25 2016

POSITIVE RECALL

EFFECTIVE 11/07/22 AUTH LC

RELEASED LC DATE 11/08/24

per DSI 9749

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, July 19, 2016 10:18:04 AM

Page 1

Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.23 NEW ISSUE LL VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5C15A		Purchased	No				Each	23.0000		1			
AN5C15A									**				PC DAS 28 9-89
Bolt													

DAS
27
9-89

Location	Loc Qty	Loc Code
over003	20	
M135058	20	
ST337	3	
M130466	3	

AN5C34A		Purchased	No				Each	104.0000		2			
AN5C34A									**				PC DAS 28 9-89
Bolt													

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	2	
18918	2	
over004	88	
m131855	8	
m131856	8	
m132169	8	
m132381	8	
m132522	8	
m132674	8	
m133332	8	
m133917	8	
m133920	8	
m133921	8	
m134131	8	
ST336	14	
m130033	14	

JUL 27 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D206-648-013PHI Manufactured No

Each 0.0000

Start Qty: 1.00

Required Qty: 1.00

D206-648-013PHI

Ground Handling Wheel Modification

D3672-7 27 Manufactured No

Each 803.0000

**

147 486

PC

DAS 28 9-89

D3672-7

Washer, Phenolic

**

24

PC

DAS 28 9-89

Location

Loc Qty

Loc Code

FG 40
129987 25
133986 15
ST049 263
142572 263
ST051A 500
147220 500

DAS 27 9-89

24

NAS1149C0532R Purchased No

Each 352.0000

NAS1149C0532R

WASHER

**

8

PC

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

GA 60
116513 60
ST260a 200
m135056 200
ST266 92
m134756 92

D2932-2PHI Manufactured No

Each 0.0000

D2932-2PHI

Saddle RH Out, 206

D2933-2PHI Manufactured No

Each 0.0000

D2933-2PHI

Saddle RH In, 206

**

149993

JUL 27 2016

DAS 28 9-89

**

149991

AUG 19 2016

DAS 28 9-89

Tuesday, July 19, 2016 10:18:05 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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OTHER : _____					

Picklist Print

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Work Order ID: 149054

149054

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D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D2938-2PHI

Manufactured No

Each

0.0000

Start Qty: 1.00

Required Qty: 1.00

D2938-2PHI

Saddle RH Out, 206

D2939-2PHI

Manufactured No

Each

0.0000

D2939-2PHI

Saddle RH In, 206

AN3C41A

Purchased No

Each

302.0000

AN3C41A

Bolt

Location

Loc Qty

Loc Code

FG

10

122843

5

124975

1

m130081

4

OVER002

225

m132169

75

m132381

75

m132522

75

ST347

67

131651

67

Manufactured No

Each

477.0000

D2652

D2652

Bushing

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

124

147559

124

ST012a

308

145959

308

DAS
27
9-89

DAS
27
9-89

1 149986 149983 8 PC

DAS
28
9-89

16 PC DAS 28 9-89

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____	
Description Work Order Deviation		Disposition		Completed By _____	
				Lead hand / Supervisor Approval Verification _____	
				QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

MS21043-3

Purchased No

Each

Start Qty: 1.00 20

Required Qty: 1.00

MS21043-3

Nut

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	11	
m130673	11	
GA	237	
m133990	237	
OVER007	400	
m135058	400	20
ST302	142	
m134861	142	
ST304	106	
m131340	106	

AN5C11A

Purchased No

Each

116.0000

AN5C11A

Bolt

**

4

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	4	
103715	4	
over003	40	
M135058	40	
ST338	72	
M131305	22	
M131624	50	4

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:			QTY Effective :				MRB (QSI042) Approval 		
Description Work Order Deviation					Disposition						
									Completed By		
									Lead hand / Supervisor Approval Verification		
									QC / QA Coordinator Approval		
Root Cause					FAULT CATEGORY						
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Picklist Print

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN4C6A

Purchased

No

Each

345.0000

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Bolt

**

12
X M134955 P< DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	14	
103344	4	
121657	10	
ST345	331	
m134502	6	
m134861	75	
m134955	150	
m135127	100	

Each

717.0000

**

24 P< DAS 28 9-89

D3672-3

D3672-3

Washer, Phenolic

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	100	
133083	52	
134449	48	
FP001	213	
132639	213	
ST049	404	
142571	13	
146277	391	

24

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

NAS1149C0432R

Purchased

No

Each

977.0000

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

WASHER

**

24
X MISS 297 PC
DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

801

m125807

427

m134676

374

ST266

176

m134676

176

Each

753.0000

**

12
PC
DAS 28 9-89

MS21043-4

Purchased

No

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

300

m134754

300

ST302

396

m134502

96

m134943

300

DAS
27
9-89

12

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D3456-1

Manufactured No

Each

87.0000

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Washer

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	7	
25701	7	
ST037	5	
144158	5	
ST038A	75	
147066	25	
147799	50	

D3457-1

Manufactured No

Each

108.0000

**

PC

DAS
28
9-89

D3457-1

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	10	
32409	10	
ST037	98	
145625	98	

D2712

Manufactured No

Each

309.0000

**

PC

DAS
28
9-89

D2712

Set Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	55	
29962	55	
ST009	154	
140532	44	
141690	100	
89929	10	
ST012a	100	
147570	50	
147801	50	

10

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D2934

Manufactured No

Each

58.0000

Start Qty: 1.00

Required Qty: 1.00

D2934

Saddle Spacer

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

52

141428

12

147488

40

Each

69.0000

**

DAS
28
9-89

D2935

Manufactured No

Each

D2935

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

63

146008

33

147574

30

DAS
27
9-89

D206-642-522PHI
(now - 522PHI) W

1x B 1471SS

DAS
28
9-89

JUL 27 2016

DAS
27
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ - Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____											

Picklist Print

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN3C36A

Purchased

No

Each

240.0000

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Bolt

**

9
X M 135 310 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

47

101261

4

122204

2

m131367

1

m132169

40

FP001

80

m131856

1

m132381

79

OVER002

80

m133916

80

ST347

33

m132522

33

AN3C35A

Purchased

No

Each

47.0000

**

AN3C35A

Bolt

3
PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

18914

4

ST347

43

M132317

18

M133694

25

3

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Picklist Print

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Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

NAS1149C0332R

Purchased

No

Each

3,118.000

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

WASHER

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

1686

m135046

1686

GA

141

m133284

141

ST266

1291

m134736

1291

Each

992.0000

**

PC DAS
28
9-89

D3672-1

Manufactured

No

D3672-1

Washer, Phenolic

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

482

112218

8

134785

474

ST049

500

147077

500

Each

35.0000

**

PC DAS
28
9-89

D3396-3

Manufactured

No

D3396-3

Bushings

DAS
27
9-89

Location

Loc Qty

Loc Code

ST034

35

132598

12

147439

23

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
		OTHER : _____					

Picklist Print

Tuesday, July 19, 2016 10:18:05 AM

Page 11

Work Order ID: 149054

149054

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN5C35A

Purchased No

Each

61.0000

Start Qty: 1.00

Required Qty: 1.00

AN5C35A

Bolt

DAS
27
9-89

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

ST336

61

M129871

61

Each

123.0000

**

PC

DAS
28
9-89

AN5C32A

Purchased No

AN5C32A

BOLT

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

18918

4

over004

100

131650

100

ST336

19

m132102

19

Each

162.0000

**

4

PC

DAS
28
9-89

MS21043-5

Purchased No

MS21043-5

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

76

116548

76

ST302

66

m135157

66

4

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : ☐			

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. Q AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D206-642 REV. 6 OR LATER APPROVED REVISION

REF. FAA STC: SA00475SE

REF. TCCA STC: SH98-4

REF. EASA STC: EASA.IM.R.S.01320

PURPOSE:

TO ADD D206-642-521/-522 SKIDTUBE INSTALLATIONS WITH WEARPADS ONLY AS
PREFERRED BY SOME CUSTOMERS.

PARTS LIST:

PARTS LIST OF SECTION 4.7 OF IIN-D206-642 REV. Q AND SECTION 32.17 OF ICA-D206-642
REV. 6 IS AMENDED AS SHOWN BELOW TO REFLECT THE ADDITION OF D206-642-521/-522/-
561 CONFIGURATIONS.

ITEM	Qty -521	Qty -522	Qty -561	Part Number	Description
	X			D206-642-521	FLOAT SKIDTUBE INSTALLATION, LH
		X		D206-642-522	FLOAT SKIDTUBE INSTALLATION, RH
	1	1	X	D206-642-561 561-4	FLOAT SKIDTUBE
	1	1		D206-648-013	GROUND HANDLING KIT
1			1	D3274-045	SKIDTUBE ASSEMBLY
3			1	D2646	* AFT CAP (1)
4			2	AN3C4A	* BOLT (1)
5A			2	NAS1149C0332R	* WASHER (1)
5B			2	D3672-1	* WASHER (1)
20A			9	D3537-9	* WEARPAD (1)
21A			1	D3537-11	* WEARPAD (1)
26A			40	AN3C4A	* BOLT (1)
26B			40	NAS1149C0332R	* WASHER (1)
26C			40	ALS7-1032-130	* INSERT (1)
34			1	MS27039C4-06	* SCREW (1)
35			1	NAS1149C0463	* WASHER (1)
6	1			D2932-1	SADDLE, FWD OUT, LH
6		1		D2932-2	SADDLE, FWD OUT, RH
7	1			D2933-1	SADDLE, FWD IN, LH
7		1		D2933-2	SADDLE, FWD IN, RH
8	1			D2938-1	SADDLE, AFT OUT, LH
8		1		D2938-2	SADDLE, AFT OUT, RH
9	1			D2939-1	SADDLE, AFT IN, LH
9		1		D2939-2	SADDLE, AFT IN, RH

A	NEW ISSUE	AK	16.05.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9749	
MFG. APPR.	N/A		
APPROVED	<i>[Signature]</i>	TITLE ADD -521/-522/-561 SKIDTUBES	
DE APPR.	<i>[Signature]</i>		
DATE	16.05.30	SCALE NTS	
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REV. A
SHEET 1 OF 3

The skid tubes are approved per released DSI 9749 Rev.A and can be shipped.

However, I see that the DSI was amended and the skid tube part number is now -561 (not -541). Any customer sticker references -541 needs to be changed to -561. The top level part numbers (-521/-522) are unchanged.

The latest paperwork that includes DSI 9749 also needs to be in the kit.

Get Outlook for Android

From: Denis Maranda

Sent: Tuesday, August 23, 11:39 AM

Subject: PHI parts requiring engineering release.

To: Chris Provencal

Cc: William Monterroza

We need to ship the following PHI parts ASAP to Broussard. We are waiting for engineering release (+ve recall?).

D206-642-541 PHI wo 147157 kit D206-642-521 PHI wo 149051

D206-642-541 PHI wo 147155 kit D206-642-522 PHI wo 149054

Can you give us the OK?

Denis Maranda

Director of Operations

DART AEROSPACE

T 1 613 632-5200 > 255

F 1 613 632-5246

C 1 514 941-8922

1 800 556- 4166

www.dartaerospace.com

Linda Lacelle

From: Denis Maranda
Sent: Wednesday, August 24, 2016 9:56 AM
To: Linda Lacelle
Subject: FW: PHI parts requiring engineering release.

From: Denis Maranda
Sent: Wednesday, August 24, 2016 9:51 AM
To: Linda Corriveau <lcorriveau@dartaero.com>
Subject: FW: PHI parts requiring engineering release.

From: Sonia Quirion
Sent: Tuesday, August 23, 2016 12:53 PM
To: Denis Maranda <dmaranda@dartaero.com>
Subject: Re: PHI parts requiring engineering release.

OK

From: Denis Maranda
Sent: August 23, 2016 12:34:37 PM
To: Sonia Quirion
Subject: FW: PHI parts requiring engineering release.

From: Denis Maranda
Sent: Tuesday, August 23, 2016 11:57 AM
To: Lori Morris <lmorris@dartaero.com>
Subject: FW: PHI parts requiring engineering release.

Sonia was looking for an approval from engineering to release her kits .

Looks like we are Ok to ship provided the skid tube part number is revised???

Did the DSI came out after we had issued the WO?

From: Chris Provencal
Sent: Tuesday, August 23, 2016 11:04 AM
To: Denis Maranda <dmaranda@dartaero.com>
Cc: William Monterroza <wmonterroza@dartaero.com>; Melanie Fauteux <mfauteux@dartaero.com>; Shirley Hay <shay@da>
Subject: Re: PHI parts requiring engineering release.

FW: PHI parts requiring engineering release.

DM

Denis Maranda

Tue 12:34 PM

Sonia Quirion ▾

  Reply all | ▾

Inbox

You replied on 2016-08-23 12:52 PM.

 Reply all | ▾  Delete Junk | ▾ ...**From:** Denis Maranda**Sent:** Tuesday, August 23, 2016 11:57 AM**To:** Lori Morris <lmorris@dartaero.com>**Subject:** FW: PHI parts requiring engineering release.

Sonia was looking for an approval from engineering to release her kits .

Looks like we are Ok to ship provided the skid tube part number is revised???

Did the DSI came out after we had issued the WO?

From: Chris Provencal**Sent:** Tuesday, August 23, 2016 11:04 AM**To:** Denis Maranda <dmaranda@dartaero.com>**Cc:** William Monterroza <wmonterroza@dartaero.com>; Melanie Fauteux <mfauteux@dartaero.com>; Shirley Hay <shay@dartaero.com>**Subject:** Re: PHI parts requiring engineering release.

The skidtubes are approved per released DSI 9749 Rev.A and can be shipped.

However, I see that the DSI was amended and the skidtube part number is now -561 (not -541). Any customer sticker, decal, or paperwork that references -541 needs to be changed to -561. The top level part numbers (-521/-522) are unchanged.

The latest paperwork that includes DSI 9749 also needs to be in the kit.

Get [Outlook for Android](#)

From: Denis Maranda**Sent:** Tuesday, August 23, 11:39 AM**Subject:** PHI parts requiring engineering release.**To:** Chris Provencal**Cc:** William Monterroza

We need to ship the following PHI parts ASAP to Broussard. We are waiting for engineering release (+ve recall?).

D206-642-541 PHI wo 147157 kit D206-642-521 PHI wo 149051

D206-642-541 PHI wo 147155 kit D206-642-522 PHI wo 149054

Can you give us the OK?

Denis Maranda

Director of Operations

DART AEROSPACE

T 1 613 632-5200 > 255

F 1 613 632-5246

C 1 514 941-8922

1 800 556- 4166

www.dartaerospace.com

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. Q AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D206-642 REV. 6 OR LATER APPROVED REVISION

REF. FAA STC: SA00475SE

REF. TCCA STC: SH98-4

REF. EASA STC: EASA.IM.R.S.01320

PURPOSE:

TO ADD D206-642-521/-522 SKIDTUBE INSTALLATIONS WITH WEARPADS ONLY AS
PREFERRED BY SOME CUSTOMERS.

PARTS LIST:

PARTS LIST OF SECTION 4.7 OF IIN-D206-642 REV. Q AND SECTION 32.17 OF ICA-D206-642
REV. 6 IS AMENDED AS SHOWN BELOW TO REFLECT THE ADDITION OF D206-642-521/-522/-
561 CONFIGURATIONS.

ITEM	Qty -521	Qty -522	Qty -561	Part Number	Description
	X			D206-642-521	FLOAT SKIDTUBE INSTALLATION, LH
		X		D206-642-522	FLOAT SKIDTUBE INSTALLATION, RH
	1	1	X	D206-642-521 561-11	FLOAT SKIDTUBE
	1	1		D206-648-013	GROUND HANDLING KIT
1			1	D3274-045	SKIDTUBE ASSEMBLY
3			1	D2646	* AFT CAP (1)
4			2	AN3C4A	* BOLT (1)
5A			2	NAS1149C0332R	* WASHER (1)
5B			2	D3672-1	* WASHER (1)
20A			9	D3537-9	* WEARPAD (1)
21A			1	D3537-11	* WEARPAD (1)
26A			40	AN3C4A	* BOLT (1)
26B			40	NAS1149C0332R	* WASHER (1)
26C			40	ALS7-1032-130	* INSERT (1)
34			1	MS27039C4-06	* SCREW (1)
35			1	NAS1149C0463	* WASHER (1)
6	1			D2932-1	SADDLE, FWD OUT, LH
6		1		D2932-2	SADDLE, FWD OUT, RH
7	1			D2933-1	SADDLE, FWD IN, LH
7		1		D2933-2	SADDLE, FWD IN, RH
8	1			D2938-1	SADDLE, AFT OUT, LH
8		1		D2938-2	SADDLE, AFT OUT, RH
9	1			D2939-1	SADDLE, AFT IN, LH
9		1		D2939-2	SADDLE, AFT IN, RH

A	NEW ISSUE	AK	16.05.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. DSI 9749 REV. A SHEET 1 OF 3 TITLE ADD -521/-522/-561 SKIDTUBES NTS SCALE	
DRAWN	AK		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	N/A		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	16.05.30	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	Qty -521	Qty -522	Qty -561	Part Number	Description
	X			D206-642-521	FLOAT SKIDTUBE INSTALLATION, LH
		X		D206-642-522	FLOAT SKIDTUBE INSTALLATION, RH
			X	D206-642-561	FLOAT SKIDTUBE
10	8	8		AN3C41A	BOLT
11	16	16		D2652	BUSHING
12A	8	8		MS21043-3	NUT
12B	16	16		D3672-7	WASHER
13	4	4		AN5C11A (or AN5C12A)	* BOLT (2)
14	4	4		AN5C11A (or AN5C13A)	* BOLT (2)
15A	8	8		NAS1149C0532R	WASHER
15B	8	8		D3672-7	WASHER
16	12	12		AN4C6A	BOLT
17A	24	24		D3672-3	WASHER
17B	24	24		NAS1149C0432R	WASHER
18	12	12		MS21043-4	NUT
37	10	10		D2712	SET SCREW
38	2	2		D2934	SADDLE SPACER
39	2	2		D2935	SADDLE SPACER
50	9	9		AN3C36A	BOLT
51	3	3		AN3C35A	BOLT
52	24	24		NAS1149C0332R	WASHER
53	24	24		D3672-1	WASHER
54	12	12		MS21043-3	NUT
55	2	2		D3396-3	SPACER
56A	1	1		AN5C35A	BOLT
56B	1	1		AN5C15A	BOLT
60	2	2		AN5C32A	BOLT
61	2	2		AN5C34A	BOLT
62	4	4		MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-045 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9749	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ADD -521/-522/-561 SKIDTUBES NTS	
DATE	16.05.30	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Work Order ID 149054

Tuesday, July 19, 2016 10:18:01 AM

149054

Page 1

Item ID: D206-642-522PHI Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible
 Start Date: 7/19/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/27/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: JUL 19 2016 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-512								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

CHG006
see attachment
 DAS
 21
 9-89

DAS
 21
 9-89
 JUL 27 2016

Change Record

PAGE 1 OF 1

Part Number: D206-642-521PHI/-522PHI

Description: FLOAT SKIDTUBE , LH/RH[illegible]

Linda Lacelle

From: David Shepherd
Sent: Thursday, August 25, 2016 12:08 PM
To: Linda Lacelle
Cc: Lori Morris
Subject: RE: PHI parts requiring engineering release.

Linda,

Sorry for the slow reply. DSI 9748/9749 were approved by the FAA and released several weeks ago, so I am OK with you signing off the Positive Recall on Work Orders for PHI.

Regards,
David

From: Linda Lacelle
Sent: August-23-16 11:05 AM
To: David Shepherd <dshepherd@dartaero.com>
Cc: Lori Morris <lmorris@dartaero.com>
Subject: FW: PHI parts requiring engineering release.
Importance: High

Hi David,
Since Chris and Will are not here, can you give me the ok to sign off the positive recall for these w/o's. they were stamped positive recall, waiting on the release of the DSI, and now that they are ready to package, we would like to get these moving...
Thx
L

From: Lori Morris
Sent: Tuesday, August 23, 2016 1:03 PM
To: Linda Lacelle <llacelle@dartaero.com>
Subject: FW: PHI parts requiring engineering release.

From: Lori Morris
Sent: Tuesday, August 23, 2016 1:01 PM
To: Denis Maranda <dmaranda@dartaero.com>
Subject: RE: PHI parts requiring engineering release.

Hi Denis,

The work orders were updates manually to pull the -541PHI, as these were started before the DSI was released.

We are now building -561PHI for all future orders, as the DSI was only released at the end of July.

Thanks

Lori

From: Denis Maranda

Sent: Tuesday, August 23, 2016 11:57 AM

To: Lori Morris <lmorris@dartaero.com>

Subject: FW: PHI parts requiring engineering release.

Sonia was looking for an approval from engineering to release her kits .

Looks like we are Ok to ship provided the skid tube part number is revised???

Did the DSI cane out after we had issued the WO?

From: Chris Provencal

Sent: Tuesday, August 23, 2016 11:04 AM

To: Denis Maranda <dmaranda@dartaero.com>

Cc: William Monterroza <wmonterroza@dartaero.com>; Melanie Fauteux <mfauteux@dartaero.com>; Shirley Hay <shay@dartaero.com>

Subject: Re: PHI parts requiring engineering release.

The skidtubes are approved per released DSI 9749 Rev.A and can be shipped.

However, I see that the DSI was amended and the skidtube part number is now -561 (not -541). Any customer sticker, decal, or paperwork that references -541 needs to be changed to -561. The top level part numbers (-521/-522) are unchanged.

The latest paperwork that includes DSI 9749 also needs to be in the kit.

Get Outlook for Android

From: Denis Maranda

Sent: Tuesday, August 23, 11:39 AM

Subject: PHI parts requiring engineering release.

To: Chris Provencal

Cc: William Monterroza

We need to ship the following PHI parts ASAP to Broussard. We are waiting for engineering release (+ve recall?).

D206-642-541 PHI wo 147157 kit D206-642-521 PHI wo 149051

D206-642-541 PHI wo 147155 kit D206-642-522 PHI wo 149054